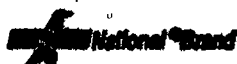


M/TID

CONFIDENTIAL 83



**College Ruled White Paper
Single Subject Notebook**

80 Sheets/9½ x 6"

Reorder # 33-580

Made in USA

 **AVERY
DENNISON**
Office Products
Chicopee, MA 01022

9/27

M/700 - RECEIVER O.D. - 1.555/1.560

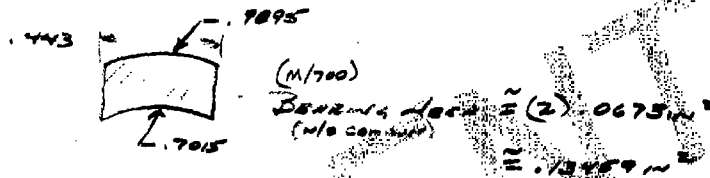
- RECEIVER/BARREL OVERLAP - .700/.725

- EJECTION PORT LENGTH - 3.22/3.25

- Bolt Head Len O.D. - .9895

- RECEIVER I.D. - .7015

- Bolt Len Width - .443



- Bolt Body O.D. - .695/.698

- Bolt Shoulder O.D. - .6955

M/710 - REARNS B LUG - LUG AREA = (8) .043028 in²
(w/o 45° cam surf)
= .129069 in²

M/100 MAGNUM BARREL - Max O.D. - 1.246/1.254

83

9/37 M/710

BARREL - BARREL MAJ DIA (OUTSIDE) - 1.230 $\pm$.0015

- BOLT LUG CLEARANCE DIA - .925 $\pm$.005

- BOLT BODY CLEARANCE DIA - .708 $\pm$.003

- LUG WIDTH ϕ (3X VEE ENGAGEMENT), ASSUMED SEEN ANGLE

$$= (3)(.925 - .708) / 2 \quad (\text{at } 45^\circ)$$

$$= .325$$

$\pm$.0015

- BOLT LUG CLEARANCE WIDTH - .325 $\pm$.005

- BOLT SHROUD C'BORE DEPTH - .210 $\pm$.005

- BARREL HUB LENGTH $\pm$.800 + .325 + .210 + 2 (CLEARANCE)

$$= 1.300 \pm .005 \quad (\text{RECEIVER OUTLET})$$

- BOLT SHROUD C'BORE DIA $\pm$.704/.707

- BOLT LUG WIDTH CLEARANCE $\pm$.400 $\pm$.005

- TAKE DOWN THREADS - 1/4-28

BOLT - BOLT SHROUD DIA - .695 $\pm$.002

- (NOTE - DERKS LUG WIDTH IN BOLT .400)

- BOLT BODY DIA - .899 $\pm$.003 .001 MIN CLEARANCE
.010 MAX CLEARANCE

RECEIVER - FORCE FIT TORQUING

(PER MACH. HANDBOOK Pg 647/234)

- FN3 - FORCE FIT CLASS 3

↳ HOLE 1.230 $\pm$.001

↳ SHAFT 1.230 $\pm$.0026

i.e. RECOMMENDED TOLERANCE $\pm$.001/.0026

↳ ASSUME $\pm$.0005 ON BARREL HUB

1.2285	MIN BARREL
- .001	MIN INTF
1.2275	MAX REC. HOLE
- .0015	NOM TOL
<u>1.226</u>	NOM. REC. C'BORE

RECEIVER CONT'D

- BOLT CLEARANCE DIA - .906 $\pm$.003 $\rightarrow$ NOW INSPECTED
- WEB THICKNESS MAX OPENING TO BEL C BORE - .120
- MAX VSEL OPENING LENGTH - 3.75 $\pm$.010
- BEL C BORE DEPTH 1.300 $\pm$.005
- MAX WELL WIDTH AT REAR - ~~1.041~~ $\pm$.010
- MAX WELL WIDTH AT FRONT - ~~1.005~~ $\pm$.010
- 7/3/90 - RECEIVER I.D (TUBE) - 1.046 $\pm$.003
INS.
- OAL - 6.400 $\pm$.005
- EXTER. PORT WIDTH - .590 $\pm$.005
- EXTER PORT LENGTH - 4.10 BAN MILL
- MAX WELL WIDTH - .812 $\pm$.005
- FIRE CONTROL ^{STOP} WIDTH - .310 $\pm$.005
- FIRE CONTROL STOP LENGTH - 1.100 $\pm$.005
- RECEIVER O.D. - 1.400 $\pm$.005
- BOLT HANDLE CLEAR DEPTH - .570 $\pm$.010
- FER FACE TO FER TAKE DOWN - .8375
- BOLT STOP CLEAR HOSE DIA - .279 $\pm$.002
- B.S. FLAT .67 $\pm$.005
- B.S. HOSE PDS .598 $\pm$.005

14/7500 MAXIMUM BOL OVERALL LENGTH - 3.552

Bolt Cont'd - Proto Mat'ls - 8640

- Bolt Shroud Length = $.215 \pm .005$
- Bolt Lx Width = $.300 \pm .005$
- Bolt Shroud Dia = $.695 \pm .002$
- Bolt Body Dia = $.899 \pm .003$ → .001 MIN CLEAR. w/ REG.
.010 MAX CLEAR
- Bolt Lx Width = $.370 \pm .005$

* 9/8/88 - Small Bolt Body Lx. $.695 \pm .002$

83

CONFIDENTIAL

RECEIVER SCREEN/INSERT

- O.D. - $1.045 \pm .002$ - $(1.043 \pm .003 / 1.046 \pm .001)$
- I.D. - $.915 \pm .005$
- Bolt Lug Width (Clear) - $.380 \pm .003$
- Bolt Body Clear Dia - $.701 \pm .002$
- Inside Receiver Length - $(5.100 - .050) = 5.050 \pm .005$
- Port Width - $.600 \pm .005$
- Max Well Width - $.530$
 $.562 \pm .005$
- Max Well Position From Front - $.045$
- Eject Port From Front - $.650$
- Eject Port Length - 3.850
- Max Well Length - 8.700
- Side Port to Eject Port Dist
- $X = .850$
- $Y = .621$
- Nominal Wall - $.065"$
- Side Port Riser Holes - $.097 \pm .0015$
- B.S. Clear Hole - $.290 \pm .005$

BOLT BODY

- BODY DIA - .695 $\pm$.002
- LENGTH - 5.065 $\pm$.005
- I.D. - .490 $\pm$.003
- BOLT PIN RECESS I.D. - .600 $\pm$.005
- BOLT HEAD PIN HOLE DIA - .250 $\pm$.002
- HOLE POS. FROM FRONT FACE - .215
- BOLT PIN RING DEPTH - .450 $\pm$.005
- BOLT HEAD PIN HOLE - .250 $\pm$.002
- 1/13/98 - BOLT PIN LUG CLEAR. - .2502

Photo Shop 8640

- Bolt Head
- BODY SECT DIA - .495 $\pm$.002
 - FIRING PIN HOLE DIA - .075 $\pm$.002
 - REAR F. P. HOLE DIA - .150 $\pm$.002

83

Bolt Plug

- SLEEVE O.D. - .490 $\pm$.003
- SLEEVE LENGTH (BETWEEN SHOULDERS) - .465 $\pm$.005
- LUG O.D. - .590 $\pm$.003
- LUG WIDTH - .120 $\pm$.003
- BODY O.D. - 1.395 $\pm$.005
- BOTTOM LUG WIDTH .860 $\pm$.005
- LUG SHEAR AREA LENGTH - .1809" } BASED ON .042 LUGS
- LUG SURFACE AREA IN CONTACT w/ ROT BODY - .006096 in²
- .125R Q.1165 LUGS

LUG AREA LENGTH - .229457 IN

LUG SURFACE AREA - .0067 IN²

Bolt Head

- SHAFT DIA - .274 $\pm$.002
- PADDLE WIDTH - .400 $\pm$.005
- SHAFT TO PADDLE EDGE - .575
- SHAFT LENGTH .295

FIRING PIN

S&W LONG ACTION - FIRING PIN MASS - .094 lbs.

- TIP DIA - .0685

SAVAGE LONG ACTION - FIRING PIN MASS - .087 lbs

- TIP DIA - .0671

M/700 LONG ACTION - FIRING PIN MASS - .1419 lbs.

83

- BOLT HEAD TO BOLT PLUG LENGTH - 4.065

- BOLT HEAD LENGTH (REAR TO BE) - 1.126

- BOLT PLUG TO SEAR LENGTH - 1.028

TIP (HEAD)

- TIP DIA - .067 ± .001

- SHAFT DIA - .143 ± .002

- HEAD DIA - .405
- HEAD DIA - .405 ± .003

- HEAD WIDTH - .400

ALUM. TOR = .0594 lb.

- STROKE - .235

SPEAR TOR = .110959 lb.

- THREAD - #12-28 UNF.

- MASS - .0149 lbs.

HEAD (1010)

- MASS - .015784

SHAFT (1010)

- O.D. - .275 ± .002

- TIP THREAD - #12-28 UNF.

- LENGTH (BETWEEN) 4.590
4.540

- TIP THREAD LENGTH - .150 ± .005

- HEAD THREAD LENGTH - .225
- HEAD THREAD LENGTH - .275 ± .005

- HEAD THREAD - #12-28

- MASS - (ALUM.) .02876

	<u>DESIGN</u>	<u>DWG</u>	<u>REQ. P.O.</u>
* - BARREL	✓	D 5806	77881
* - RECEIVER	✓	E 5826	77881
• RECEIVER INSERT	✓		
* - Bolt Head	✓	D 5827	77881
* - Bolt Body	✓	D 5830	77881
- Bolt Assy Pin	✓	B 5842	77883
- EXTRACTOR	✓		
- EJECTOR			
- EJECTOR SPRING			
- EJECTOR RET. PIN			
* - Bolt Handle	✓	C 5885	77881
- Bolt Handle Pin	✓	A 5841	77883
- Bolt Plug	✓	D 5843 5992	77882 88120
* - F.P. Head	✓	C 5836	77881
* - F.P.	✓	C 5837	77881
* - F.P. TIP	✓	C 5838	77881
- F.P. SPRING	✓		78912
- RIGHT SIDE PLATE	✓	C 5844	77883
- SIDE PLATE PIN (Hous. Assy)		AW 5840	77883
- SAFETY			
- SAFETY DETENT SPRING			
- SAFETY BUTTON			
- TAKE DOWN SCREWS ⁴⁸ #12 (2)			
- SLANT ASSY'S			
- MAGAZINE BOX	✓		78708
- LATCH	✓		
- TRIANGLE GUARD	✓		
- Bolt STOP			
- STOCK	✓		79139

Side Plate Rivet

- Body Dia = .101 $\pm$.0015
- Head Dia = .182 $\pm$.005
- Shank Length = .205 $\pm$.005
- Head Width = .045"

Bolt Handle Pin

- OD = .255 $\pm$.002
- Length = .828 $\pm$.005

Bolt Assy Pin

- OD = .247 $\pm$.005
- Length = .690
- Hole Dia = .145 $\pm$.001

83

FIRING PIN SPRING

- Bolt Body I.D. = .498 ± .003 = .495 min
- Firing Pin O.D. = .275 ± .002 = .277 max
- Fired Length = 3.665
- Locked Length = 3.480
- Stroke = .285

Ex. 1 - $F_1 = 19.25$ $X_2 = 6.015 - 3.665 = 2.35$

$F_2 = 17.50$ $X_1 = 6.015 - 3.480 = 2.535$

$K = 7.4468 \text{ lb/in}$ $M = .111$

$E_{\text{RECY}} = \frac{1}{2} K (X_1^2 + X_2^2)$
 $= \frac{1}{2} (7.4468) (2.535^2 + 2.35^2)$

$= 13.18 \text{ in lbs.}$

$E = 69.08 \text{ in ozs}$

$T = \frac{\cos^{-1}(\frac{X_2}{X_1})}{\sqrt{K \Delta L}}$ in

$= \frac{.4297}{9.453} (.0587129)$

$T = .00267 \text{ sec}$

INERTING

- FRONT TO FRONT TAKE DOWN - 10.8375
- DIST BETWEEN TAKE DOWN - 1.700
- FRONT TO REAR FOLE - 11.700
- REAR LENGTH 6.400 P. 66P43
- REAR TO BBL SPREADING - 1.1742
- REAR TO MIDDLE TAKE DOWN SCREW - 6.960
- REAR T.D. POST DIA - .445
- REAR T.D. POST DEPTH - 1.109
- REAR OF REAR TO SPREADING OF TAIL - .315
- REAR TAIL CLEAR REAR - .283
- FIRE CONTROL SLOT WIDTH - .840
- F.C. SLOT TO REAR T.D. CL - .550
- F.C. SLOT (FRONT) TO REAR T.D. CL - 2.520
- F.C. SLOT DEPTH FROM BBL CL - 2.055
- TRIANGULAR SLOT FROM REAR OF F.C. - 1.215
- LATCH WIDTH - .495
- LATCH CLEAR FRONT TO BACK - .357
- REAR BARRIER WIDTH - .205
- R.B. FRONT POST TO T.D. FRONT - .3075
- R.B. SLOT WIDTH - .700

83

SARCO FIRM PIN SPAN:

COMPRESSION = FREE LENGTH TO CORNER PDS = 1.065

FREE LENGTH = 2.790

STAGGER = 2.10"

$$P_r^{\#1} = X = (DFFL) = .282 .208$$

$$L_1 = 3.085 < 0.0160$$

$$P_r^{\#2} = X = (DFFL) = .716$$

$$L_2 = 15.46$$

$$P_r^{\#3} = X = (DFFL) = .849$$

$$L_3 = 17.96$$

$$K_{12} = \frac{(L_2 - L_1)}{(X_2 - X_1)} = \frac{9.46 \text{ in}}{482 \text{ in}} = 21.8 \text{ lb/in}$$

$$K_{13} = 18.80 \text{ lb/in}$$

$$K_{13} = \frac{1196}{566} = 21.1 \text{ lb/in}$$

Assume $K = 21.4 \text{ lb/in}$

$$\therefore L_c = \text{Loop Length} = 22.791$$

10/16

DESIGN REVIEW

- FLION

- BASE

- .025 MAX RAD.

(GRIND $\pm .0005$)

- 1.00 R POUN. ?

- Bolt Flange

- Lug

- THREADED UNION ?

- Bolt Body

- Lug Clearances $1/4"$?

- Bolt Head

- EXTENDED COR. .005" OFF OF FACE

- Rec. Insulator

- No Corners, - No Ribs.

83

Rapid Prototype Items for Cosmetic Sample

- RECEIVER INSERT ✓
- BOX BOTTOM ✓
- FOLLOWER ✓
- LATCH ✓
- TRIGGER GUARD ✓

710. REC-INSERT - SOLID

710. BOX - BOTTOM

710. FOLLOWER

710. LATCH

710. TRIGGER GUARD

FILE TO PERMIT FOR BUILD

11/16/78

RECEIVER INSERT

TODD COOK EST.

ALUMINUM - #3/16 → #4.90/16

VOLUME ≈ 1.8

CAVITATION - 2

20.7 SEC TOTAL CYCLE

LABOR RATE \$37.79/Hr

↳ #.40/PART

11/16/78 DESIGN REVIEW - CHANGE RATES AS OF 7/80

REC. INS. - #3 SC ^{END OF PART} US #.40 (ETODN EST) MAT'L \$.47

- MATERIAL - (COOP. OF VERDON)

- TOTAL CYCLE - TRT

- CYCLE TIME 40 SEC / 1 CAVITY

- SYN TRAIL RATE CYCLE TIME

* - MOLD FLOW ANALYSIS

↳ CYCLE TIME

↳ MATERIAL

↳ CAVITATION

* - POSITIONAL TOLERANCE - GREATER THAN .003

OD 30 - POTENTIALLY MOODEN

- NEED THREADED INSERT

* - SCREW POCKETS OPEN FACE

Bolt Head

- OP 80 ?
- Mill Lugs - No Cost due to OP combinations
- Common to M/700 Bolt Head
- Cam Cut on Barrel vs Bolt Head

Bolt Plug

- Lug Strength
- Potting Cost based on cycle
cycle vs rec. ins.

Stem Assy

- (6.12 + 1.41) 700 ADL
- Barrel Pin Outsourced - $\approx$ 1.00
- Same Cost as 700 ADL
- L Pin Saw w/ Butt Plate (\$2+)

Misc Comp. - Screw Machine Parts out for quote

Flank Pin - More Thread Clearance for Roll Thread

Bolt Holder - \$1.80

Barrel Blank

- Seamless Pre Hard

Barrel - Lug Cam ?

- Turn vs. Polish (Same Cost)
- Add Slight Costs

Firing Pin Head

- Mim

Receiver

- OUTSOURCE - Rollmark - Serial #

Bolt Body

- OUTSOURCE

Bolt Assy

- OP 40 ?
- OP 60 ? - Not Required ?

Barrel Assy

- OP 30 Removed
- OP 40 "

11/12 Parts to Cannon B610 Build
 → #88129 - \$4218.00

Bolt Body	2 PCS.	1010-1020 OR 1100 SERIES
Bolt Head	2	8640
RECEIVER	2	1010-1020 OR 1100
Bolt Handle	2	1010-1030
F.P. Tip	2	8620
F.P. Head	2	1010-1030
F.P.	2	1010-1030
Side Plate	2	1010-1030
Bolt Handle Pin	2	1010-1030
Side Plate Pin	4	1010-1030
Assembly Pin	2	1010-1030

← Barrel Seats 15 Rem. SPR 155
 #88221 (1/10/89)

Part to KENNEDY

#88082 - Receiver Insert - 1 part \$3550 Not to exceed.

#88120 - Tear Bolt Pin - 2 part cap \$300

1/3

Bolt Pad Calculations

↳ F.P. SPRING FORCE - (CALLED) 19.25 lbs.

↳ LUG SURFACE AREA = .006096 in²/LUG



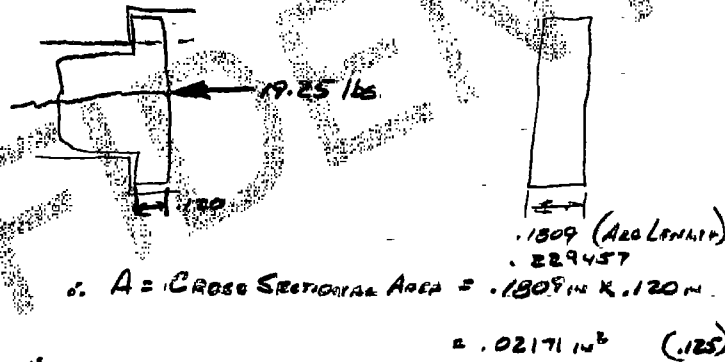
$$\tau_L = \frac{\text{LOAD}}{\text{AREA}} = \frac{9.625 \text{ lbs}}{.006096 \text{ in}^2} = 1578.9 \text{ psi/LUG}$$

$$\tau_L (.125 \text{ in}) = \frac{9.625}{.0067} = 1436.6 \text{ psi/LUG}$$

83

SHEAR -

ASSUME PERF CROSS SECTION



WAKES
Pg 5.18

$$\text{SHEAR STRESS MAX} = \text{REAR AREA} = \frac{3(\text{LOAD})}{2(\text{AREA})}$$

$$S_{V(\text{MAX})} = 1330 \text{ PSI}$$

$$S_{V(\text{MAX}, .125 \text{ in})} = 1048.7 \text{ PSI}$$

1/14 - SAH/SONN/CARLO/MIKE S./DANNY/MIKE K.

- RECOIL PAD - ADL - OK

- GRIP CAP - ADL - RECOGNITION?

↳ SHAPE OK → NEW TOOL

↳ ARMWORK REQUIRED - w/ COLOR DIFFERENTIATION

- SPORTSMAN LOGO

* → TARGET APPLIC FOR FINAL ARMWORK

↳ GOLD "R" LOGO WITH BLACK BORDER

COST?

↳ M. SANTINO

83

CARLO TO DRAW - LOGO

- CROWN - RESEMED - MTN RISE

- FRONT SIGHT - ADL SIND.

①

- CONTOUR BBL - TRANSITION - TURN/POUCH 2.10

↳ CARLO MIKE S TO WORK w/ FRANK

- REAR SIGHT - SPIS 78 - VISUAL CALIBRATIONS?

↳ MIKE SANTINO

- RECEIVER - TRANSITION TO BOLT PUNCH - FLUSHOR LOWER TO

- SPORTSMAN 710" ROUNDMAN 6 BOLT PUNCH

- EJECTION PORT - OK

②

- BOLT HANDLE - CASTING? - CNC .90

700 \$2.22

- CARLO/JAY/SONN

- BBL w/ SWEEP

- MAGAZINE - UNIFORM w/ MAX .015"

- SCISSOR SWEEP INSERT - TEST w/o INSERT

- COMPETITIVE EVALUATION

③

- BOLT PUNCH - CARLO

- SAFETY BUTTON - OK.

- RECEIVER INSERT - RADIUS CHANGES FOR WOOD STOCK

1/14 CONT'D

- SIDE CONTOUR - 700
- TAILWHEEL COVERED - O.K. - 700 WIDTH
- 700 FRONT PAD.
- FINISH - ISSUES FOR PART IDENTIFICATION
- WINNERS CHOICE - TEXTURE SIMILAR TO BBL
- STOCK - LATCH OPENING - O.K.
- LATCH - CLOSE FROM BOTTOM
- BOX FIT UP GOOD
- BOX BOTTOM - SIDE TEXTURE
- LOGO - JOHN/SHY "NO"
- TOOL COST FOR INSERT
- STOCK - REAR TAKE DOWN - FINANCIAL
- ESCUTCHEONS
- BOLT STOP - "JURY" REQUIRED
- PM REQUIRED
- BOLT PIN - INSERT MOUNTED STAKE (UN. PIECE)

1/15 - MANBOX 5403 FIVE TO TURNER PRECISION ATTN: MARK B.
PER HAROLD BROWN.

1/18 - BOLT RUN STL FIVE TO GARDNER PERFORM

1/19 - BOLT RUN 5403 (4)

REQ # 88739

1/22 REQ # 89553 - MOD FROM ANALYSIS - \$3000

89554 - MAN BOX DEVEL.

1/25 REQ # 89819 - CAMERA REMOVED

1/26 REQ # 89998 - STAIN (ALUM)

2/1 REQ # 90683 - REC INE - OSCA'S

2/8 - Measurements

- Firing Pin Head

5'8022 - .0545/.058

A to Bottom (.882) - .334/.321

(.440 width) - .4395/.4385

(.170 width) - .169/.1705

(.565+.085) - .649/.649

- Firing Pin Tip

1.142+.025
(1.175)

1.1335/1.137

- Firing Pin

(4.590)

4.5865/4.592

- Side Plate OK

- Base Plate OK

- Base Head

.3714/.1001 - .867/360

2/10 - Firing Pin Tip Measurements

1.176/1.1725

83

2/9

Hanson - 2 Cavity

- 30% Glass Material - Pre Heat Mold.
- \$8000/Time for Hardened
- 1st Cavity P20, Exp. w/ 30-40%
- Ejection Port - Spruing Pull?
- Length - Add .025" → 5.075
- Bolt Handles Thin Rib .268 to .210
- Top Core - In Line Ejector Side of Rib
- B.B. .365 vs. .265/0.6 to match Ejection Port
- Top Gate - Optimize Side Rib/Side Gate

* To Do - Press Fit Force Req.

83

2/9

TIT -

P20 - Insect Gate

2/10

George - Hansen Group (413) 589-0584 (235)

- Hole Toesman +.0000
-.0015

- Straightness - Bon to Leaf

2/11

Ray - Hole Toesman +.0005 - Received Insect
-.0015

Req # 92412 - Bon Heads.

2/12

- Received 2 Bon Heads

- E-mailed RIZ1299.263 to Hanson

2/15

910. FOL-SURF File to General Patton

2/17

Press Fr Calc.

Maehne's Handbook Pg 637

$$P = \frac{A \cdot F}{2}$$

$$A = \text{SURF AREA} = (77 \times 1.227 \times 1.227)$$

$$a = (.0015 \times 1.227)$$

$$F = 395 \text{ (Tack)}$$

$$\therefore P = 1.83 \text{ tons.}$$

83

2/17 PARTS READY FOR DETAILING.

Pr No. -

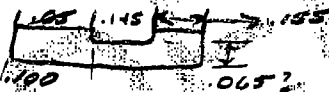
PARTS/MDK/710/RECEIVER

2/19 M/710 ACTION - 6000 DRY FIREWIRE w/o FAILURE.

INCHES BEFORE DRY CYCLING .012, .013, .015 (CUTTING)

2/22 INCHES AFTER DRY CYCLING .013/.014

EJECTOR - .188 DIA F. 202



SPRING LOAD P.S. - .391/.251

MAX BOA (.473 Nom DIA)



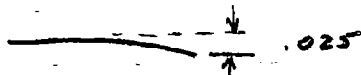
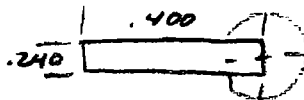
$$\cos 30^\circ = \frac{x}{.473} = .4096$$

$$\therefore .4096 + .473 = .8826 \text{ BOA WIDTH}$$

SAFETY - 30 DEG ROTATION

: LOW POS (R) - 8.0 DEG BOW HOGG

.03" MAIL THICKNESS



MACHINERY HANDBOOK - P. 328

$$P = \frac{E b^3 \delta}{4 L^3} = \frac{(29,400 \times .240 \times .03)^3 (.025)}{4 (.4)^3}$$

$$P = 18.35 \text{ lbs.}$$

$$T_B = \frac{6 P L}{b \delta^3} = \frac{6 (18.35 \times .4)}{(.240 \times .03)^3}$$

1095 MAT'L
 $T_Y = 150,000$

$$T_B = 203,889 \text{ psi}$$

∴ @ .025 MAT'L THICKNESS - $P = 14.98$

$$T_B = 190,896 \text{ psi}$$

@ .026 MAT'L THICKNESS - $P = 11.95$

$$T_B = 176,775 \text{ psi}$$

@ $L = .45 / .025 \text{ MAT'L}$ - $P = 10.48$

$$T_B = 150,382 \text{ psi}$$

* @ $L = .45 / .026 \text{ MAT'L}$ - $P = 8.39$

$$T_B = 139,626 \text{ psi}$$

83

	DIA	LENGTH
TRIGGER PIVOT HOLE -	.1254/.1264	
SEAR PIVOT HOLE -	.1255/.1265	
✓ SEAR & TRIGGER PIN DIA -	.124/.125	.300 ±.003
INERT HOLE DIA -	.1235/.1205	
✓ SIDE PIVOT HOLE DIA -	.124/.125	.126 ±.0005
✓ SAFETY PIN -	.122/.125	.428 ±.003
✓ SAFETY HOLE -	.126 ±.0005	

CONFIDENTIAL 83

CONFIDENTIAL

1

83